

by a single clamping operation. Lever *A* draws out plunger *B* and throws in sleeve *C*, operating the plungers *D* and *E*. Plungers *E* are smaller in diameter than plungers *D* and permit of enough

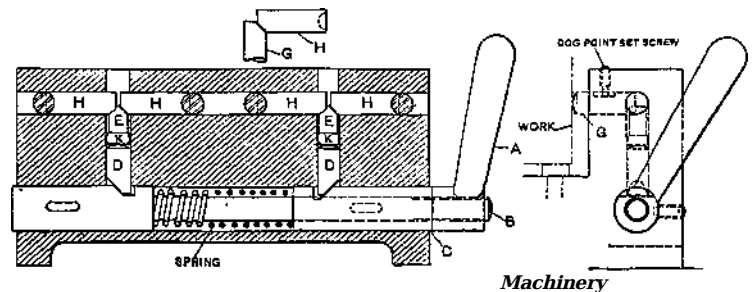


Fig. 20. Locating Mechanism where Two Pieces are Located and Clamped in a Single Operation

lateral movement to equalize plungers *G* through the auxiliary plungers *H*.

Fig. 21 represents a milling fixture with a quick-release feature. The particular work illustrated is milling a flat on a small bush-

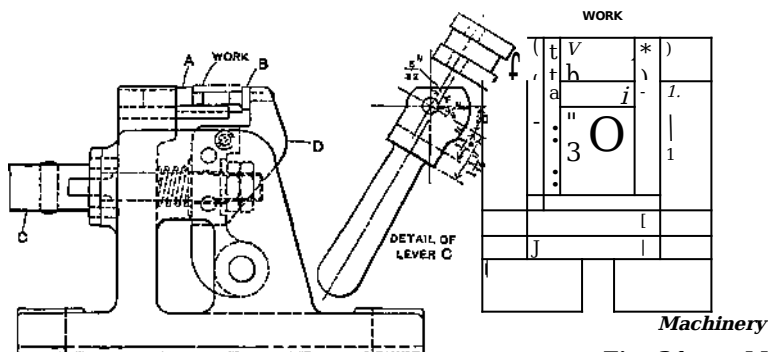


Fig. 21. Milling Fixture with a Quick-release Feature

ing made on the screw machine. The bushings are held on the pins *A* and *B* and clamped with the eccentric handle *C*, which draws in the hinged leaf *D*. Details of

the quick-release lever are given. Fig. 22 illustrates half of a fixture for milling a cylindrical